

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004059**Date Inspected:** 21-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Sun Bo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Tower Shop Bay 3 Deck Panel repairs

The QA Inspector randomly observed ZPMC personnel performing grinding of repairs for the Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that fourteen (14 ea) deck panels are inside the shop. This QA inspector along with ZPMC and ABF personnel performed the 3 party initial visual inspections. All 3 parties agreed on the repair areas and signed the yellow ABF tracking tag affixed to the deck panel. The deck panels inspected were DP581-001 and DP591-001. ZPMC was started grinding the locations marked by the inspection for the remainder of the shift. Certified Welding Inspector for ZPMC Sun Bo was present at this location for the monitoring of the deck repairs and inspection. Also noted in bay 3 to monitor deck panel repairs were ABF personnel Wang Zhong Yuan and Ding Bao Hua.

89m Mock-up Submittal SUB101R2

This QA inspector observed that ZPMC had removed fit lug MUB-MA21-G/J-25/26 for preparation of continuing the weld trial for the 89m mock-up. This QA Inspector was informed that ZPMC was to weld tomorrow 9-22-08 for this location.

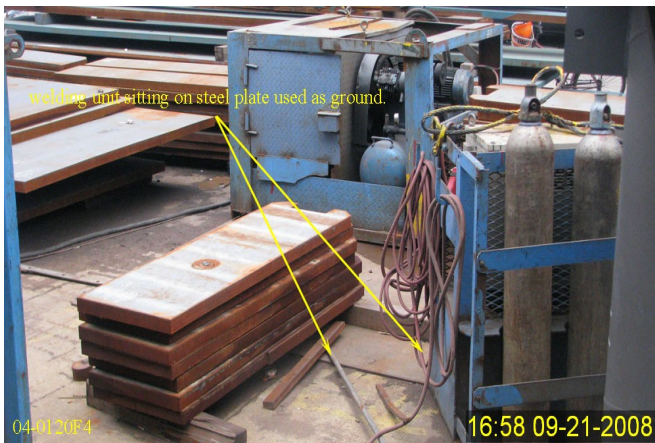
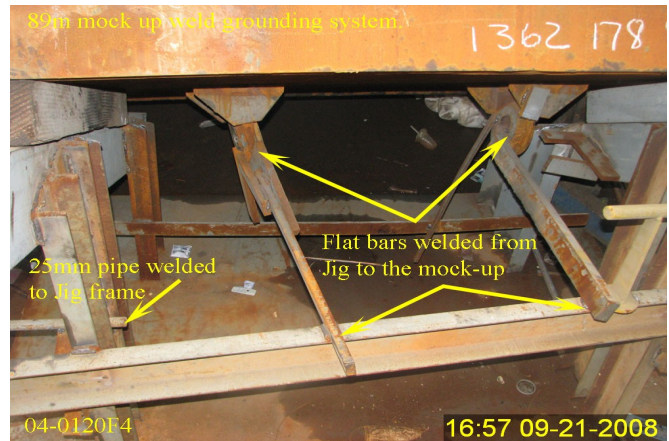
OBG Bay 1

The Caltrans QA observed ZPMC has approximately thirty (30) to forty (40) workers performing various functions relative to the fabrication of the OBG Deck Panels. These functions include; closed rib milling, PJP weld joint beveling, drilling thru holes, press forming, closed rib splice welding, closed rib diaphragm fit-up and FCAW welding of splices, closed rib to deck plate fit-up and tack welding and the PJP welding of closed ribs to deck plates. Deck Plates at the gantry stations were, Gantry-1 DP416-001 GMAW and SAW welding completed previously. ZPMC earlier in the shift had performed MT for the tack weld locations on 3 welds only at the time the Caltrans QA Inspector returned to the bay no further progress was noted. Gantry 2, DP335-001 tack welded and

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

MT performed on 248 tack weld locations with 30 indications of which 18 were identified as cracked welds.
DP335-002 had been completed previously with the SAW and GMAW welding processes.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco , 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Riley,Ken

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer